

Work Order ID 73929



Page 1

Monday, September 19, 2011 12:50:18 PM

Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 9/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-02-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG.006

Suluico

[Signature] Per MLS 11-11-9

73929.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes.as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

11/10/26

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: ☐ M118736

88 11/10/26
11/10/26

12-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 11/10/26

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/10/26

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11-10-26

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-10-27

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	<p>Memo</p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3-Open float holes to .500" (4 per Side)</p> <p>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6-Prepare tube for welding, remove alodine as required..</p> <p>7-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> Sikaflex-291 batch: 119398 <input type="checkbox"/> <input type="checkbox"/> exp. date: 12/08/13</p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R <input type="checkbox"/> Aluminum Rod batch: m118736</p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404"</p> <p>10-Grind welds flush as per Dwg D2750</p> <p>11-Spot face ground handling holes section (total of 4 places per side) as per</p>	0.00							

11-10-27

11/10/27

11/10/29

11/10/31

Dart Aerospace Ltd

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

dwg D2750

12-Debur holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

11.11.01

11/10/31

1

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11.11.01

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1XJ M-L 11/11/02

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8-10OVEN TEMPERATURE: 320 °FFINISH TIME: 8-40*1XJ M-L 11/11/03*

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 BR 11-11-8.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Abstract

Page 8

Accept

**Setup Start**

Stop

Page 10 of 10

Cust Item ID:

Customer:

Reference:

Run Start

[illegible]

Stop

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

230

0.00

00000000000000000000

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: N/A.

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH:

EXP DATE: 01/01/2010

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o-ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 114596

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
250 Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

*Me I**11/11/10*

280

0.00



QC21 - Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*11/11/14**11-11-14*

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per
 IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225 Purchased

No

Each

1,883.000

38



Insert

BR 11-11-8.

Location

Loc Qty

Loc Code

ST282

1883

110768

62

117717

9

118386

860

118696 ✓

952

34

AN3C5A

Purchased

No

230

Each

1,062.000

34

34



Bolt

BR 11-11-8.

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1055

116419

28

117343

356

117764

169

117872

2

118451 ✓

500

34

Dart Aerospace Ltd

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Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

288.0000

4

4



BOLT



BR 11-11-8.

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

287

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

37

118422

200

AN6C44A

Purchased

No

230

Each

83.0000

4

4



BOLT



BR 11-11-8.

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

81

118332

31

118387

50

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Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

123.0000

1

1



BOLT



BR 11-11-8

Location

Loc Qty

Loc Code

FP

87

117511 ✓

21

118286

66

FP-A

1

115960

1

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

X NAS1149C0332
R

Purchased

No

230

Each

0.0000

38

38



washer

118354



38.

BR 11-11-8

D2745

Manufactured

No

230

Each

245.0000

8

8



Bushing



BR 11-11-8

Location

Loc Qty

Loc Code

FP-A

83

69529

83

ST023

162

71835 ✓

162

8

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Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042 Manufactured No

230

Each

25.0000

1

1



Blade Fitting Assembly, RH



BR 11-11-8.

Location

Loc Qty

Loc Code

FP008

25

62003

1

68109

4

69904

9

71883

11

1

D3492-1 Manufactured No

230

Each

8.0000

8

8



Plug



BR 11-11-8.

Location

Loc Qty

Loc Code

FP

8

69531

8

8.

D3492-3 Manufactured No

230

Each

109.0000

8

8



Plug



BR 11-11-8.

Location

Loc Qty

Loc Code

FP

109

71838

100

72126

9

8.

D3535-25 Manufactured No

230

Each

9.0000

1

1



Wearshoe



BR 11-11-8.

Location

Loc Qty

Loc Code

FP018

9

62233

1

69743

8

1

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:27 PM

Work Order ID: 73929

Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 9/19/2011



Required Date: 9/30/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	12.0000	1	1
							<u>BR 11-11-8.</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012 74526	12	1
70780	12	

D3537-1	Manufactured	No	230	Each	70.0000	3	3
							<u>BR 11-11-8.</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001 74436	60	3
72124	60	
FP016	3	
68944	0	
70687	3	
FP017	7	
69817	5	
70686	2	

D3631-1	Manufactured	No	230	Each	187.0000	8	8
							<u>BR 11-11-8.</u>
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST072	187	8
68062 ✓	187	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:27 PM

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230 Each

19.0000 1 1



Wearplate



BR 11-11-8.

Location

Loc Qty

Loc Code

FP017

74507.

7

62239

2

69282

5

FP17

12

72158

12

D3793-1 Manufactured No

230 Each

11.0000 1 1



Wearshoe



BR 11-11-8.

Location

Loc Qty

Loc Code

FP018

74591.

11

70781

11

D3793-3 Manufactured No

230 Each

17.0000 1 1



Wearshoe



BR 11-11-8.

Location

Loc Qty

Loc Code

FP018

74593

17

70813

5

72160

12

D3794-1 Manufactured No

230 Each

17.0000 1 1



Gasket



BR 11-11-8.

Location

Loc Qty

Loc Code

FP010

74509.

17

70779

17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:28 PM

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3
Gasket

Manufactured No

230 Each

8.0000 1 1



BR 11-11-8.

Location

Loc Qty

Loc Code

FP018 74530
70812

8
8

1

MS21043-6
NUT

Purchased No

230 Each

545.0000 4 4



BR 11-11-8.

Location

Loc Qty

Loc Code

FG
103693
ST301 112314 ✓
117887
118384

20
20
525
315
10
200

4.

MS21083C8
NUT

Purchased No

230 Each

97.0000 1 1



BR 11-11-8.

Location

Loc Qty

Loc Code

FP-B
115884
ST293
118077
ST303
115884
118354
118614 ✓

1
1
22
22
74
0
24
50

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:28 PM

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R Purchased

No

230

Each

356.0000

1

1



WASHER



BR 11-11-8.

Location

Loc Qty

Loc Code

FP-B

27

114915

27

ST297

329

114915

329

NAS1515H3L

Purchased

No

230

Each

180.0000

4

4



WASHER



BR 11-11-8.

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

140

113362

57

118686

83

NAS1611-010

Purchased

No

230

Each

175.0000

8

8



O-RING



BR 11-11-8.

Location

Loc Qty

Loc Code

FP

161

117460

8

118077

1

118612

152

FP-A

14

110915

14

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:28 PM

Page 9

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

172.0000

8

8



O-RING



BR 11-11-8.

Location

Loc Qty

Loc Code

FP

119438

55

117291

2

117887

53

FP-A

117

116582

5

118384

112

8.

AN8C21A

Purchased

No

250

Each

93.0000

2

2



BOLT



Location

Loc Qty

Loc Code

ST345

93

118045

43

118758

50

2

D2741

Manufactured

No

250

Each

39.0000

1

1



Blade, 350 Skidtube



Location

Loc Qty

Loc Code

ST466

39

69133

1

70667

38

1

D3493-1

Manufactured

No

250

Each

73.0000

2

2



Washer



11/11/9

Location

Loc Qty

Loc Code

ST062

73

70697

33

71846

40

2

Monday, September 19, 2011 12:50:28 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:28 PM

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

15.0000

2

2



Spacer



B73342

Location

Loc Qty

Loc Code

ST065

15

69895

15

MS21083C8

Purchased

No

250

Each

97.0000

2

2



NUT



M119309

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

22

118077

22

ST303

74

115884

0

118354

24

118614

50

NAS1149D0863J

Purchased

No

250

Each

152.0000

2

2



WASHER



2

Location

Loc Qty

Loc Code

ST298

152

118078

152

D2600-3-BENT

Manufactured

No

110

Each

9.0000

1



Extrusion Bent



11/10/26

Location

Loc Qty

Loc Code

LG

9

66875

8

72153

1

Monday, September 19, 2011 12:50:29 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:29 PM

Page 11

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

73.0000

1

1



Cap



BE 11/10/24

Location

Loc Qty

Loc Code

LG002

17

62715

1

70881

16

WA

56

71861

56

D2739

Manufactured No

160

Each

9.0000

1

1



350 I Beam



BE 11-10-27

Location

Loc Qty

Loc Code

LG

9

70823

1

72154

4

72155

4

D2743

Manufactured No

160

Each

166.0000

8

8



Crossbolt Spacer



BE 11/10/29

Location

Loc Qty

Loc Code

LG

108

69818

5

71839

103

LG001

58

67766

4

68251

54

8

Monday, September 19, 2011 12:50:29 PM

Shop Packet Print

Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 19, 2011 12:50:29 PM

Page 12

Work Order ID: 73929

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 9/19/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160

Each

10.0000

4

4



Cross Bolt Spacer



BE 11/10/29
B 73295 x 4

Location

Loc Qty

Loc Code

LG

10

70768

10

D3490-1 Manufactured No

160

Each

82.0000

4

4



Cross Bolt Spacer



BE 11/10/29

Location

Loc Qty

Loc Code

LG

80

67773

5

69823

10

71841

65

LG001

2

62450

2

4

Monday, September 19, 2011 12:50:29 PM

Shop Packet Print

Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73929

011-0819

RELEASED

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

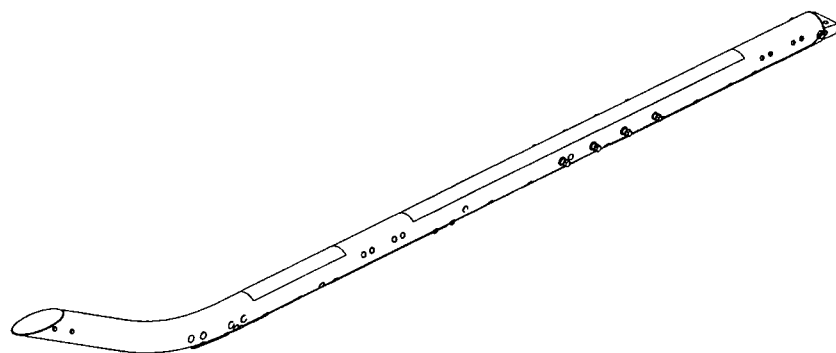
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

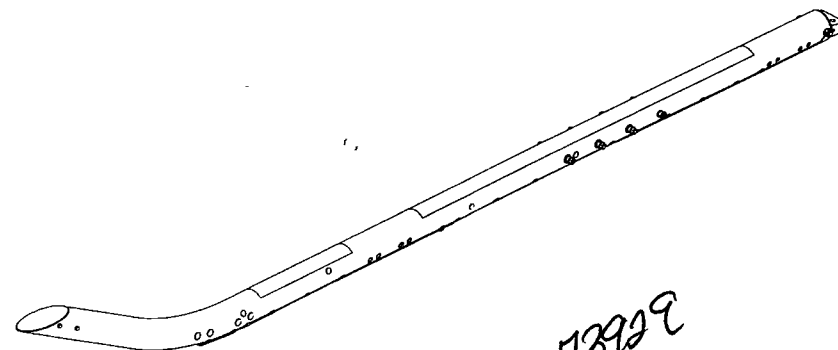
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
18-09-22-14

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

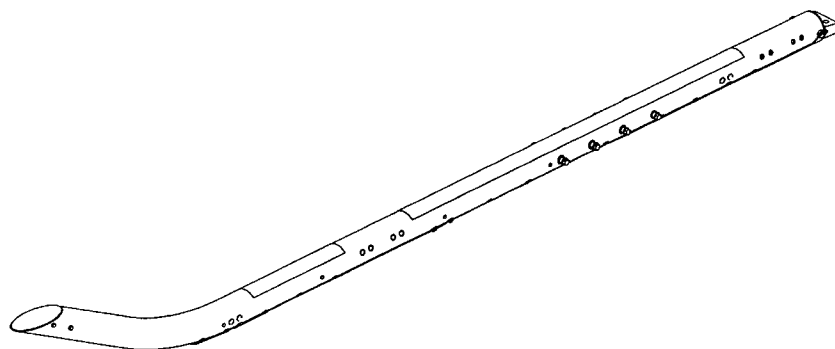
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

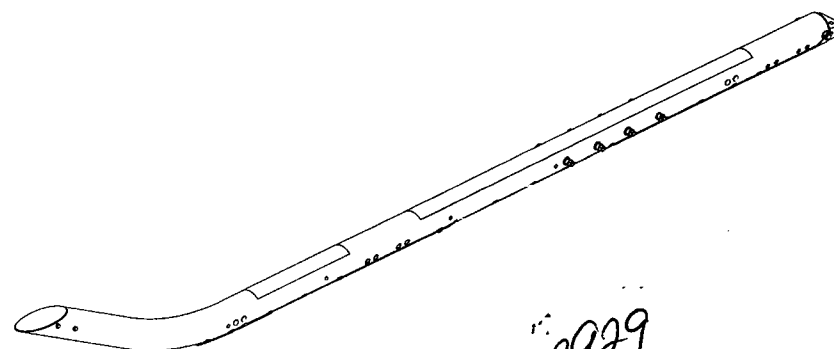
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

73929

RELEASED
68-19-22/100

DESIGN	PC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PC		
CHECKED	JA	DRAWING NO.	REV. F
MFG. APPR.	JA	D2750	SHEET 3 OF 11
APPROVED	JA	TITLE	SCALE
DE APPR.	JA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

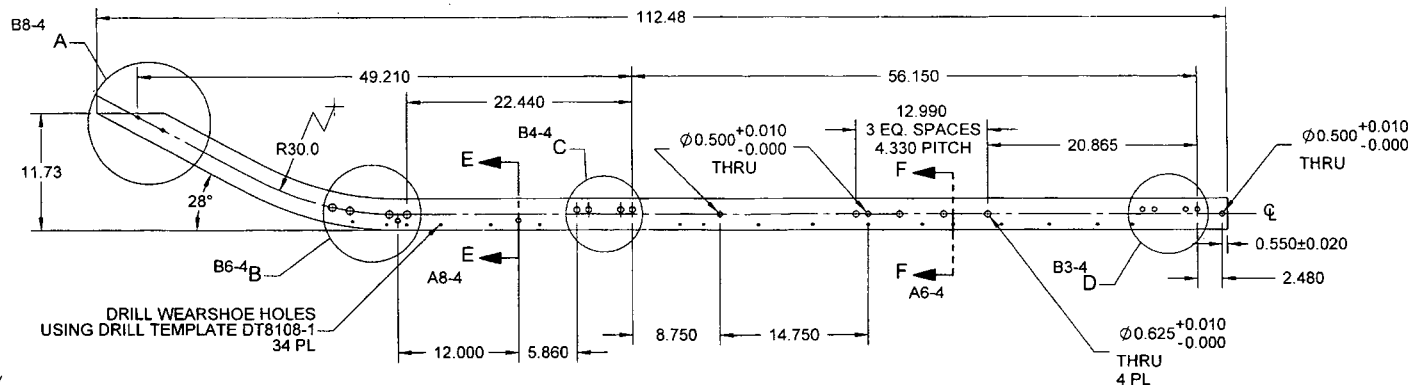
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

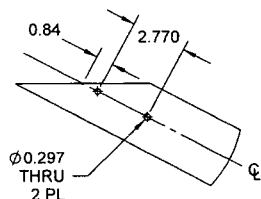
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

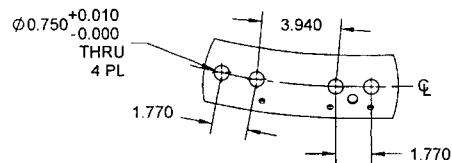
NOTE: Date & initial all entries



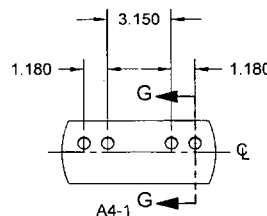
D2750-1 LH SKIDTUBE



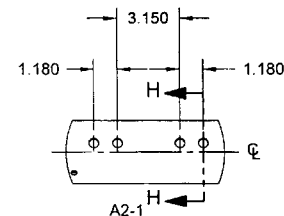
DETAIL A
SCALE 2X



DETAIL B
SCALE 2X

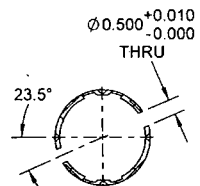


DETAIL C
SCALE 2X

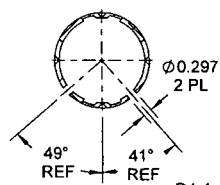


DETAIL D
SCALE 2X

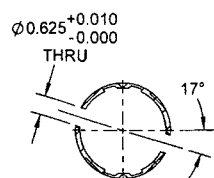
13929



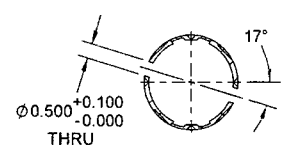
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL






SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 4 OF 11
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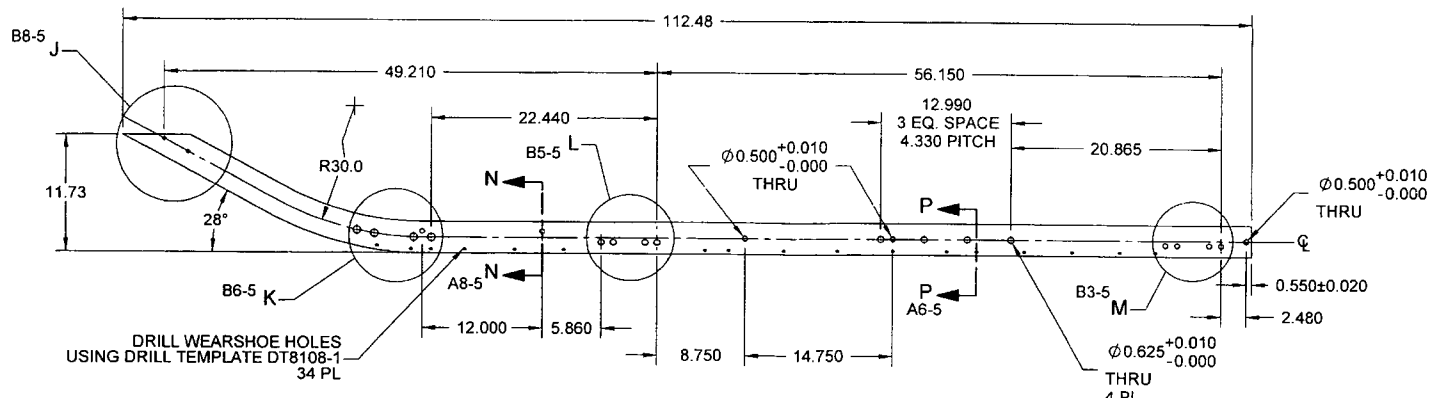
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

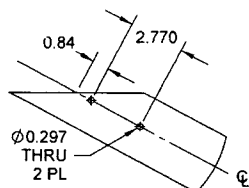
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

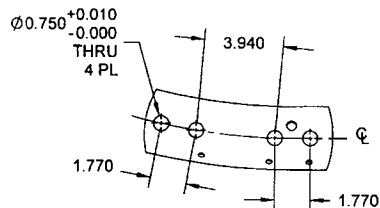
NOTE: Date & initial all entries



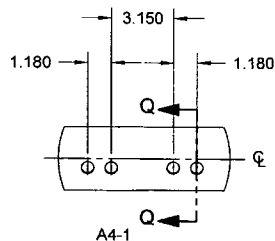
D2750-2 RH SKIDTUBE



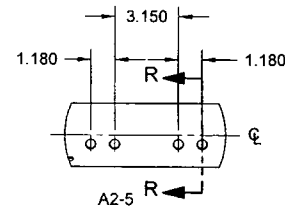
DETAIL J
SCALE 2X



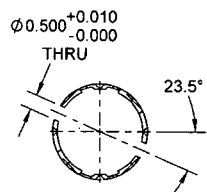
DETAIL K
SCALE 2X



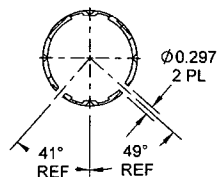
DETAIL L
SCALE 2X



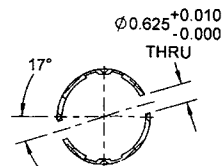
DETAIL M
SCALE 2X



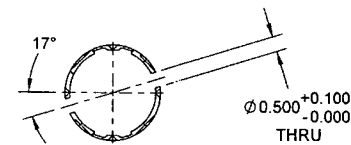
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

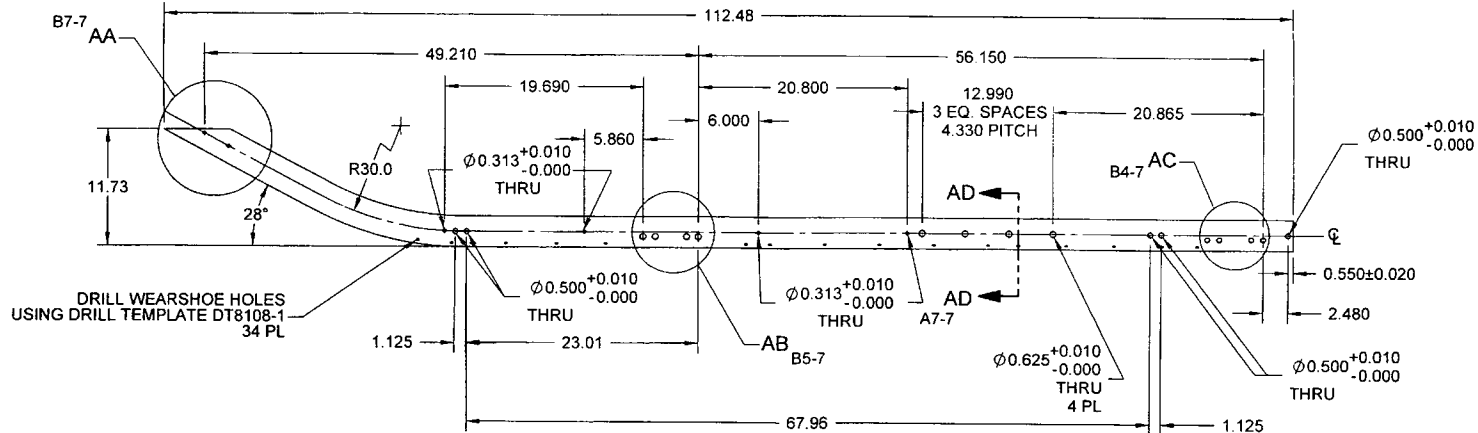
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

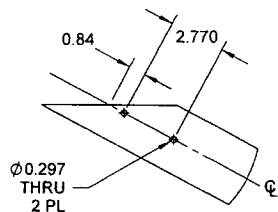
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

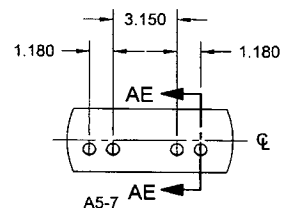
NOTE: Date & initial all entries



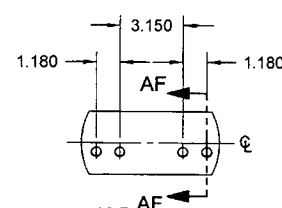
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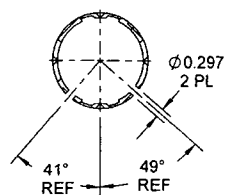
DETAIL AA
SCALE 2X



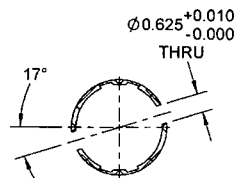
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SCALE 2X



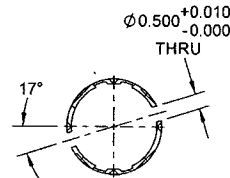
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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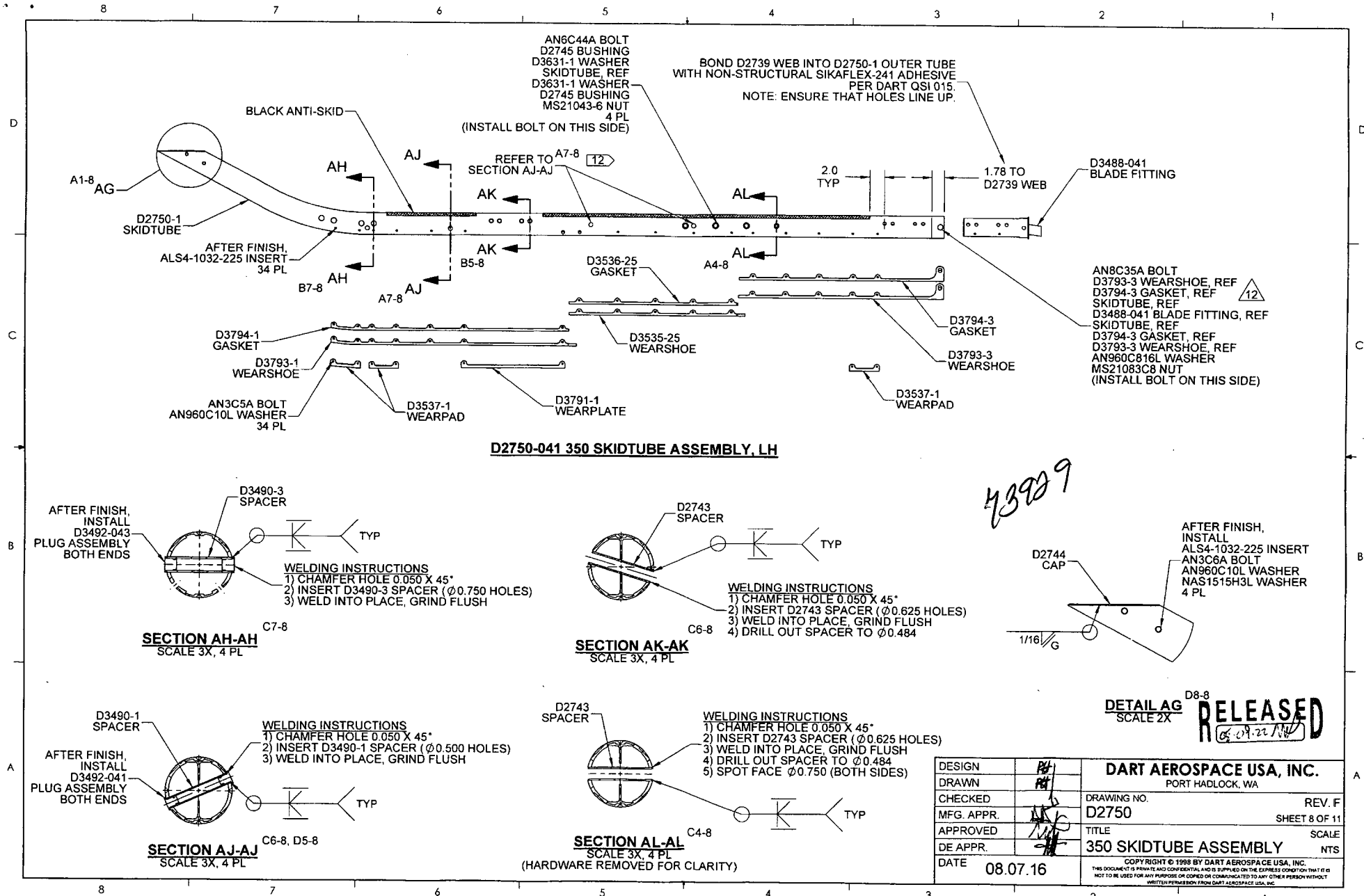
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

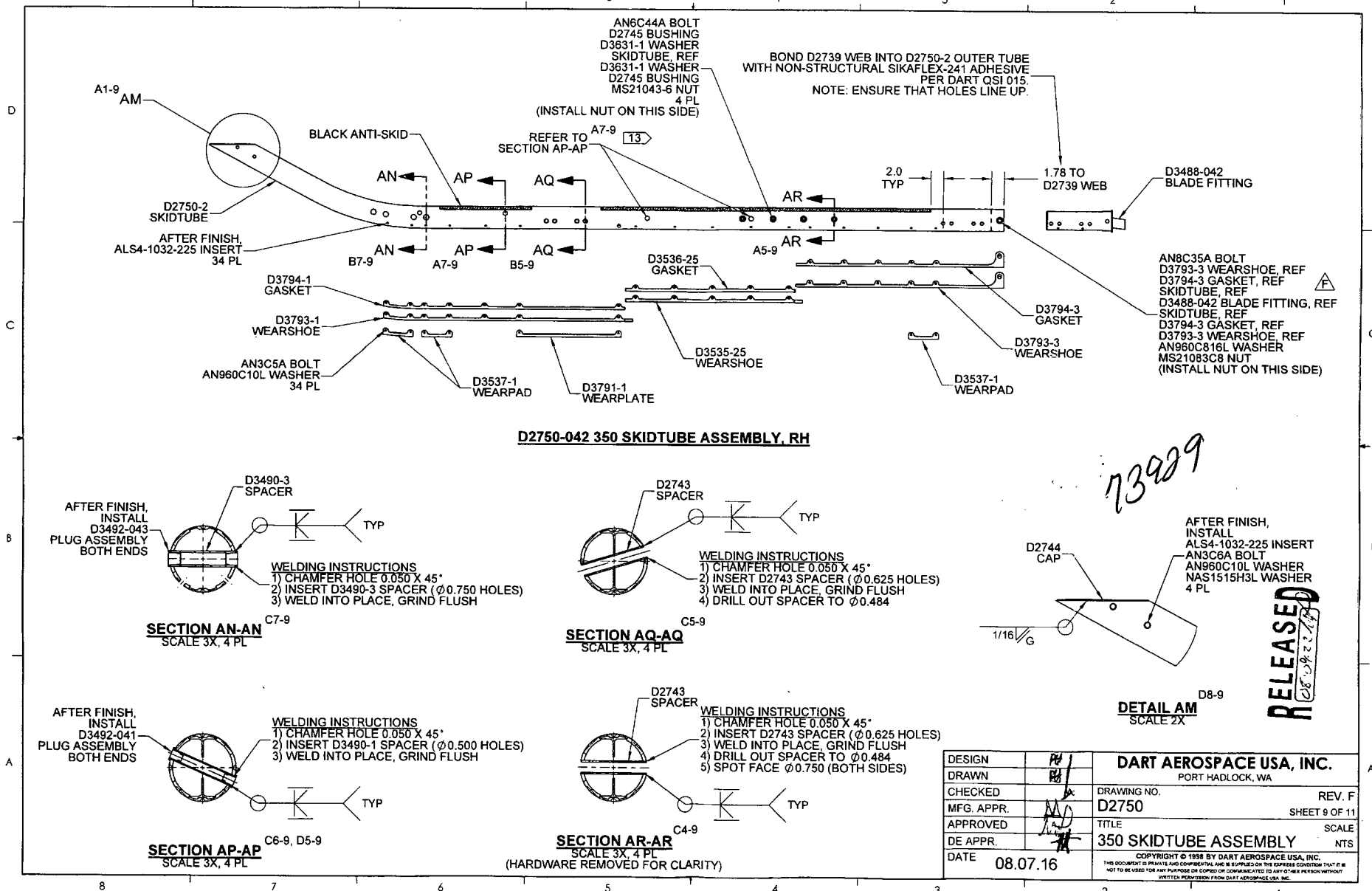
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2

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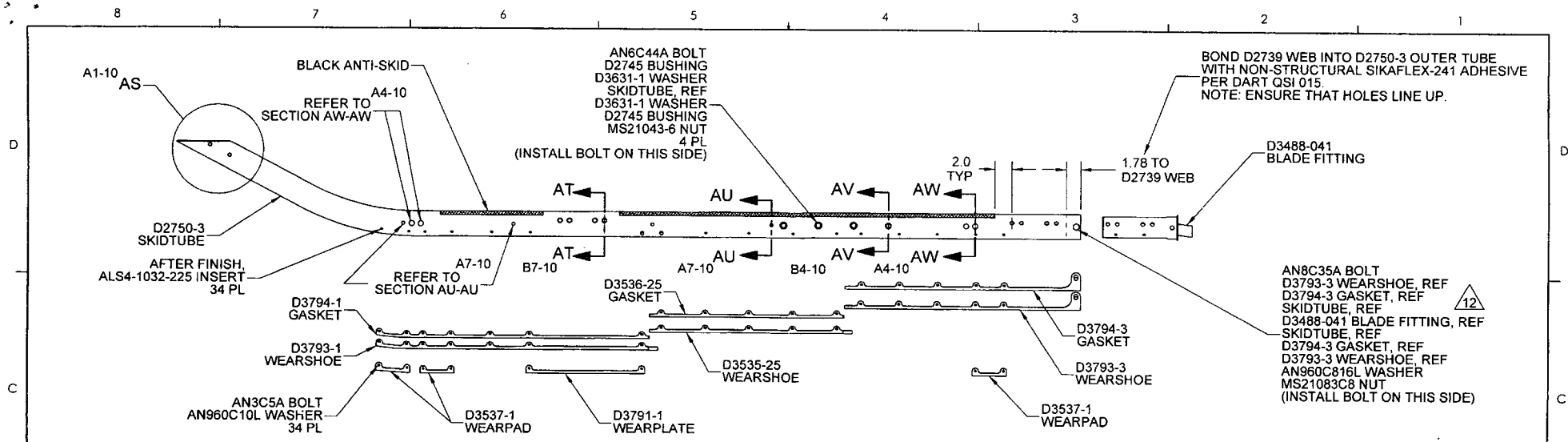
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

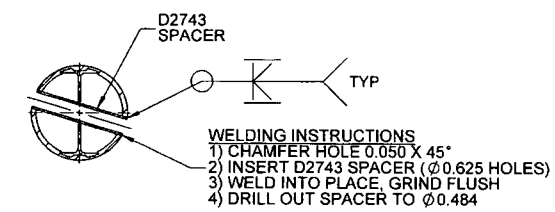
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

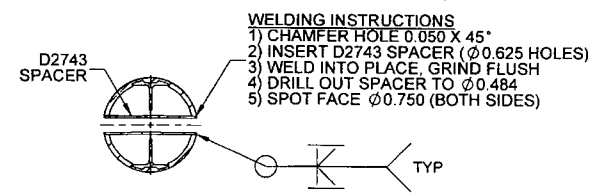
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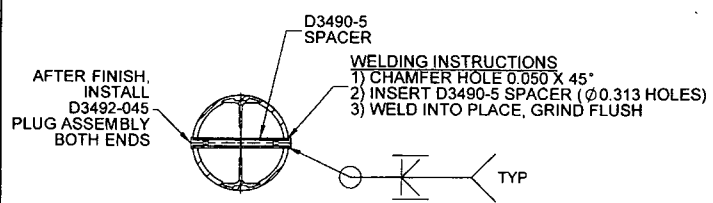
D2750-043 350 SKIDTUBE ASSEMBLY, LH



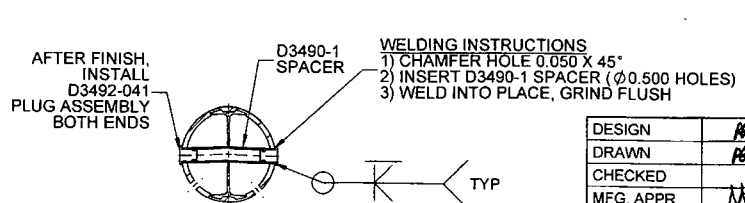
SECTION AT-AT
SCALE 3X, 4 PL



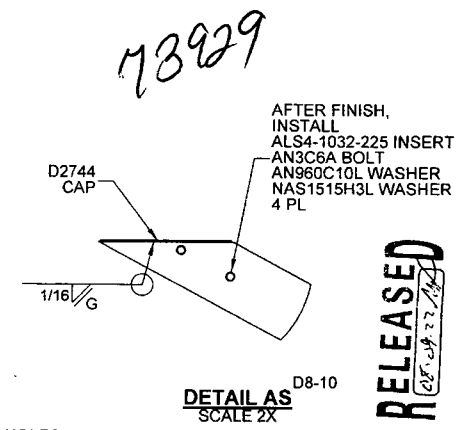
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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2015-04-22

W/O:		WORK ORDER CHANGES					
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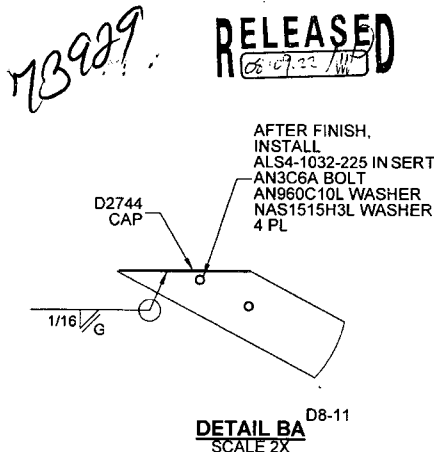
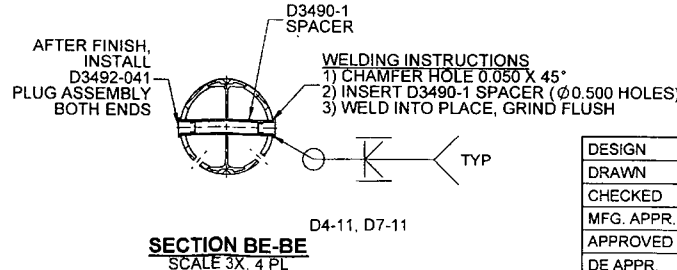
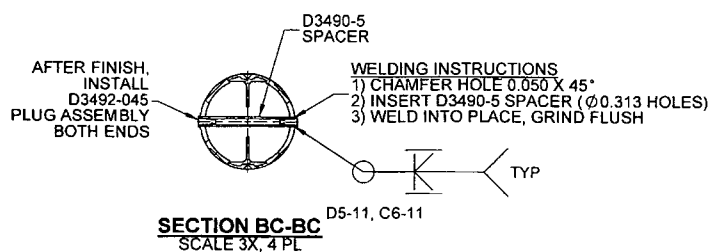
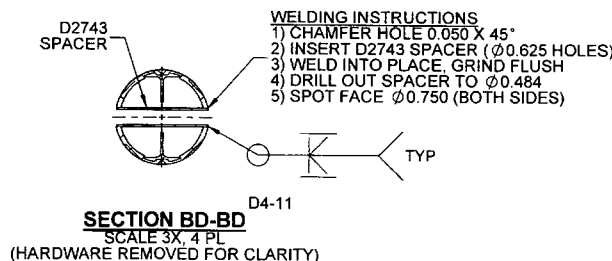
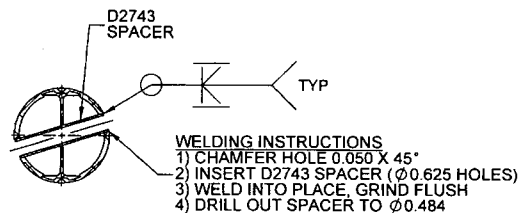
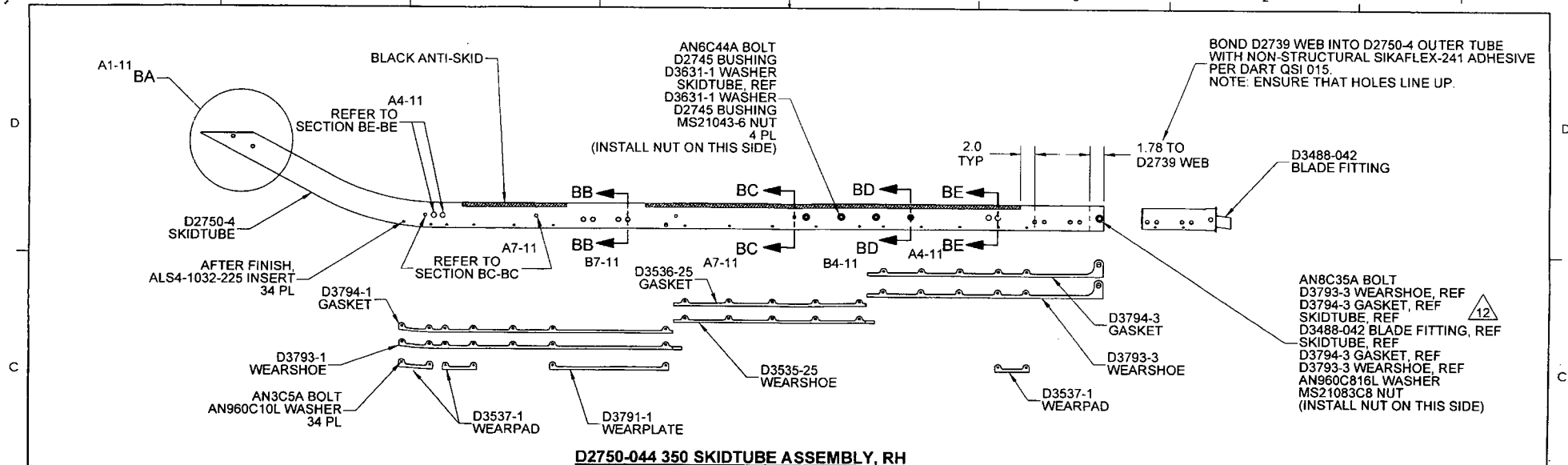
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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8 7 6 5 4 3 2 1



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries